

ABSTRACT

The invention provides a A build-up mold for continuous casting that can be produced at low costs by simplifying cumbersome positioning operations when milling or cutting slit grooves in a copper plate that becomes a cooling plate, is able of making uniform the cooling efficiency over the entirety of the cooling plate by adjusting pressure loss and flow amount of cooling water flowing into the respective slit grooves, and is able to prevent break out and defects of molded pieces in continuous casting of molten metal without generating strains in the cooling plate, wherein the yield of molded pieces can be improved. The build up mold for continuous casting 10, in which a cooling plate having a plurality of separate and unconnected slit grooves forming cooling channels by a supporting panel attached to the cooling plate using tightening members, wherein supporting panel 17 is attached, via tightening members 13 through 15, to the opening side of slit grooves of the cooling plate 11 in which a number of slit grooves 20 through 29 becoming flow passes of cooling water are formed, is characterized in that the widths width of the slit grooves 20, 29 disposed so as to bypass next to the tightening members 13 through 15 in the vicinity thereof are formed to be is wider than the widths width of the other slit grooves which are disposed in a range having a high cooling efficiency between the tightening members, and while the depths depth of the all slit grooves are formed to be roughly equal to each other substantially the same.